

Date: Thursday, 7/20/2006 1:05:43 PM
 User: Linda Lacelle

Process Sheet

Customer:	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 27992		
Estimate Number	: 10530		
P.O. Number	: <i>N/A</i>	Part Number	: D2571
This Issue	: 7/20/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2571 REV E
First Issue	: 7/20/2006	Project Number	: N/A
Previous Run	: 27887	Drawing Revision	: E
	Type : MACHINED PARTS	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/5/2006
Checked & Approved By	: <i>[Signature]</i> 06.07.21	Qty:	<i>24</i> Um: Each
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: *B23941* x 23

B25354 x 1

J.G 06/08/14

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. *B27993* Double check by: *B6*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

J.G/Er

06/08/17

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

/Er

06/08/24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G/Er

06/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LS Date: 06/08/30

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:05:44 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27992

Part Number: D2571

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 06/08/24

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-08-26

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-08-28

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

P 6/8/28 (24)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

P 6/14/28 (24)
LB 06/08/28

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/30

Job Completion



CL 06/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.499	3.497	3.496		
D	1.745	1.755		1.746	1.747	1.747	1.746		
E	7.990	8.010		8.002	8.000	8.001	8.002		
F	0.490	0.510		0.496	0.497	0.496	0.497		
G	0.257	0.262	DT8683		0.258	0.258	0.258		
H	0.375	0.380	DT8684	✓	0.376	0.376	0.376		
I	0.490	0.510		0.496	0.497	0.498	0.497		
J	1.174	1.184		1.175	1.179	1.179	1.179		
K	0.558	0.578		0.558	0.568	0.569	0.568		
L	1.174	1.184		1.175	1.177	1.178	1.179		
M	1.490	1.500		1.492	1.497	1.496	1.497		
N	2.495	2.505		2.498	2.497	2.497	2.498		
O	3.869	3.879		3.872	3.871	3.871	3.871		
P	0.115	0.135		0.127	0.126	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.254	0.249		
S	0.115	0.135		0.125	0.124	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.960	2.960	2.961		
V	0.230	0.250		0.242	0.247	0.246	0.246		
W	0.115	0.135		0.116	0.117	0.117	0.118		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.363	0.364	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.620	0.621	0.600		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.245	0.246		
AE	1.375	1.395		1.385	1.384	1.384	1.389		
AF	0.115	0.135	x	0.135	0.135	0.135	0.135		
AG	0.240	0.280	x	0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.254	0.253	0.252		
AI	2.000	2.020		2.000	2.000	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En 13.0
Date:	06/08/17

Audited by:	ml
Date:	06/08/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 8		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.747	1.747	1.751	1.750		
C	3.495	3.505		3.497	3.497	3.499	3.499		
D	1.745	1.755		1.747	1.746	1.751	1.750		
E	7.990	8.010		8.001	8.000	8.001	8.002		
F	0.490	0.510		0.499	0.497	0.498	0.499		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.500	0.500	0.498	0.493		
J	1.174	1.184		1.179	1.177	1.178	1.175		
K	0.558	0.578		0.568	0.566	0.563	0.563		
L	1.174	1.184		1.179	1.177	1.178	1.175		
M	1.490	1.500		1.499	1.497	1.495	1.495		
N	2.495	2.505		2.499	2.497	2.499	2.498		
O	3.869	3.879		3.871	3.870	3.872	3.873		
P	0.115	0.135		0.124	0.124	0.125	0.126		
Q	0.115	0.135		0.127	0.126	0.125	0.135		
R	0.240	0.260		0.251	0.249	0.252	0.251		
S	0.115	0.135		0.127	0.126	0.123	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.960	2.960		
V	0.230	0.250		0.236	0.237	0.234	0.234		
W	0.115	0.135		0.119	0.118	0.119	0.119		
X	0.308	0.313		0.311	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.361	0.371	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.621	0.622	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.244	0.245		
AE	1.375	1.395		1.387	1.384	1.384	1.387		
AF	0.115	0.135		0.135	0.133	0.135	0.135		
AG	0.240	0.280		0.247	0.246	0.260	0.266		
AH	0.240	0.260		0.250	0.250	0.246	0.246		
AI	2.000	2.020		2.001	2.003	2.003	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.G. / Er
Date:	06/08/18 06/08/19

Audited by:	J.L.
Date:	06/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 27992
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 R		
A	0.438	0.443	DT8682	/	/	/	/		
B	1.745	1.755		1.750	1.747	1.745	1.748		
C	3.495	3.505		3.499	3.500	3.499	3.498		
D	1.745	1.755		1.750	1.747	1.745	1.748		
E	7.990	8.010		8.001	8.002	8.001	8.002		
F	0.490	0.510		0.496	0.499	0.496	0.498		
G	0.257	0.262	DT8683	/	/	/	/		
H	0.375	0.380	DT8684	/	/	/	/		
I	0.490	0.510		0.496	0.494	0.495	0.498		
J	1.174	1.184		1.177	1.176	1.178	1.175		
K	0.558	0.578		0.562	0.560	0.561	0.563		
L	1.174	1.184		1.177	1.176	1.178	1.175		
M	1.490	1.500		1.493	1.493	1.495	1.495		
N	2.495	2.505		2.499	2.498	2.498	2.496		
O	3.869	3.879		3.872	3.872	3.872	3.869		
P	0.115	0.135		0.123	0.126	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.251	0.250		
S	0.115	0.135		0.121	0.123	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.233	0.235	0.233	0.232		
W	0.115	0.135		0.119	0.119	0.120	0.120		
X	0.308	0.313		0.310	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.360	0.361	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.624	0.623	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.244	0.247	0.244		
AE	1.375	1.395		1.386	1.384	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.249	0.250	0.247		
AI	2.000	2.020		2.001	2.000	2.001	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: <i>EN B</i>
Date: 06/08/21

Audited by: <i>gml</i>
Date: 06/08/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	-	-	-	-		
B	1.745	1.755		1.745	1.746	1.747	1.747		
C	3.495	3.505		3.497	3.496	3.500	3.499		
D	1.745	1.755		1.745	1.746	1.746	1.746		
E	7.990	8.010		8.001	8.000	8.000	8.001		
F	0.490	0.510		0.497	0.496	0.498	0.497		
G	0.257	0.262	DT8683	-	-	-	-		
H	0.375	0.380	DT8684	-	-	-	-		
I	0.490	0.510		0.495	0.495	0.496	0.497		
J	1.174	1.184		1.177	1.176	1.178	1.179		
K	0.558	0.578		0.566	0.566	0.567	0.566		
L	1.174	1.184		1.177	1.176	1.178	1.178		
M	1.490	1.500		1.492	1.493	1.494	1.493		
N	2.495	2.505		2.499	2.497	2.496	2.497		
O	3.869	3.879		3.871	3.872	3.871	3.871		
P	0.115	0.135		0.125	0.124	0.123	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.249	0.248		
S	0.115	0.135		0.124	0.124	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.234	0.235	0.234		
W	0.115	0.135		0.120	0.121	0.122	0.124		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.367	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.251	0.251		
AE	1.375	1.395		1.387	1.388	1.390	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.251	0.252		
AI	2.000	2.020		2.002	2.002	2.004	2.004		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	CP / S.G.
Date:	06/08/22

Audited by:	J.I.
Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	27992
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 ²⁰		
A	0.438	0.443	DT8682	/	/	/	/		
B	1.745	1.755		1.749	1.747	1.747	1.749		
C	3.495	3.505		3.499	3.499	3.501	3.497		
D	1.745	1.755		1.747	1.747	1.747	1.745		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.491	0.491	0.492	0.493		
G	0.257	0.262	DT8683	/	/	/	/		
H	0.375	0.380	DT8684	/	/	/	/		
I	0.490	0.510		0.498	0.497	0.497	0.495		
J	1.174	1.184		1.180	0.180	0.178	1.179		
K	0.558	0.578		0.567	0.568	0.567	0.568		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.490	1.500		1.498	1.495	1.494	1.492		
N	2.495	2.505		2.500	2.494	2.497	2.499		
O	3.869	3.879		3.871	3.872	3.871	3.870		
P	0.115	0.135		0.134	0.133	0.134	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.251	0.252		
S	0.115	0.135		0.124	0.125	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.961	2.961	2.960		
V	0.230	0.250		0.247	0.242	0.241	0.236		
W	0.115	0.135		0.135	0.134	0.133	0.119		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.370	0.371	0.363	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.624	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.251	0.246		
AE	1.375	1.395		1.387	1.388	1.388	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.255	0.255	0.255	0.247		
AI	2.000	2.020		2.004	2.004	2.003	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G
Date:	06/08/23

Audited by:	J.L
Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	27992
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 ²⁴		
A	0.438	0.443	DT8682		✓	✓	✓		
B	1.745	1.755		1.745	1.747	1.745	1.750		
C	3.495	3.505		3.498	3.497	3.498	3.496		
D	1.745	1.755		1.745	1.747	1.745	1.750		
E	7.990	8.010		8.002	8.002	8.003	8.002		
F	0.490	0.510		0.502	0.497	0.497	0.502		
G	0.257	0.262	DT8683		✓	✓	✓		
H	0.375	0.380	DT8684		✓	✓	✓		
I	0.490	0.510		0.493	0.494	0.498	0.501		
J	1.174	1.184		1.176	1.177	1.175	1.175		
K	0.558	0.578		0.561	0.565	0.563	0.565		
L	1.174	1.184		1.176	1.177	1.179	1.175		
M	1.490	1.500		1.493	1.491	1.492	1.493		
N	2.495	2.505		2.497	2.497	2.497	2.497		
O	3.869	3.879		3.870	3.869	3.870	3.873		
P	0.115	0.135		0.123	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.253	0.252		
S	0.115	0.135		0.123	0.122	0.122	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.244	0.238	0.244	0.244		
W	0.115	0.135		0.119	0.119	0.122	0.117		
X	0.308	0.313		0.310	0.310	0.309	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.369	0.369	0.365	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.626	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.248	0.246		
AE	1.375	1.395		1.389	1.390	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.266	0.260	0.260		
AH	0.240	0.260		0.250	0.246	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	En
Date:	06/08/24

Audited by:	JL
Date:	06/08/24




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

$\triangle E$

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	 DART AEROSPACE LTD. <small>MARKHAM, ONTARIO, CANADA</small>
DS	PH	
CHECKED	APPROVED	DRAWING NO.
		D2571
DATE		TITLE
05.07.13		OUTER FWD SADDLE
		REV.
		SHEET 1 OF
		SCALE

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DETAIL C
SCALE 4:3

SECTION A-A

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WITHOUT
WORK ORDER
NO. 27992